

FORM PTO-1390 (Modified)
(REV 11-98)

U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE

ATTORNEY'S DOCKET NUMBER

TRANSMITTAL LETTER TO THE UNITED STATES

2308/100

DESIGNATED/ELECTED OFFICE (DO/EO/US)

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR

CONCERNING A FILING UNDER 35 U.S.C. 371

09/647087

INTERNATIONAL APPLICATION NO.

INTERNATIONAL FILING DATE

PRIORITY DATE CLAIMED

PCT/GB99/00975

29 March 1999

31 March 1998

TITLE OF INVENTION

APPARATUS FOR THE PRODUCTION OF POCKETED COIL SPRINGS

APPLICANT(S) FOR DO/EO/US

WHITWORTH, Ian James

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This is an express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. 371 (c) (2))
 - a. ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☐ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
7. ☐ A copy of the International Search Report (PCT/ISA/210).
8. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3))
 - a. ☐ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☐ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☒ have not been made and will not be made.
9. ☐ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
10. ☐ An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)).
11. ☒ A copy of the International Preliminary Examination Report (PCT/IPEA/409).
12. ☐ A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)).

Items 13 to 20 below concern document(s) or information included:

13. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
14. ☐ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
15. ☒ A **FIRST** preliminary amendment.
16. ☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
17. ☐ A substitute specification.
18. ☐ A change of power of attorney and/or address letter.
19. ☒ Certificate of Mailing by Express Mail
20. ☒ Other items or information:

UNSIGNED Combined Declaration and Power of Attorney.

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR 1.53) 09/647087		INTERNATIONAL APPLICATION NO. PCT/GB99/00975		ATTORNEY'S DOCKET NUMBER 2308/100	
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21. The following fees are submitted: BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)) :				CALCULATIONS PTO USE ONLY	
<input type="checkbox"/> Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO \$970.00					
<input checked="" type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO \$840.00					
<input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$690.00					
<input type="checkbox"/> International preliminary examination fee paid to USPTO (37 CFR 1.482) but all claims did not satisfy provisions of PCT Article 33(1)-(4) \$670.00					
<input type="checkbox"/> International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(1)-(4) \$96.00					
ENTER APPROPRIATE BASIC FEE AMOUNT =				\$840.00	
Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input checked="" type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (e)).				\$130.00	
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE		
Total claims	40 - 20 =	20	x \$18.00	\$360.00	
Independent claims	7 - 3 =	4	x \$78.00	\$312.00	
Multiple Dependent Claims (check if applicable). <input type="checkbox"/>				\$0.00	
TOTAL OF ABOVE CALCULATIONS =				\$1,642.00	
Reduction of 1/2 for filing by small entity, if applicable. Verified Small Entity Statement must also be filed (Note 37 CFR 1.9, 1.27, 1.28) (check if applicable). <input type="checkbox"/>				\$0.00	
SUBTOTAL =				\$1,642.00	
Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (f)).				\$0.00	
TOTAL NATIONAL FEE =				\$1,642.00	
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) (check if applicable). <input type="checkbox"/>				\$0.00	
TOTAL FEES ENCLOSED =				\$1,642.00	
				Amount to be: refunded	\$
				charged	\$

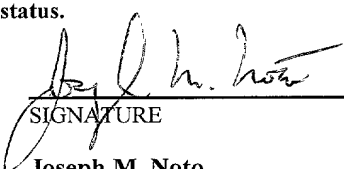
☒ A check in the amount of **\$1,642.00** to cover the above fees is enclosed.

☐ Please charge my Deposit Account No. _____ in the amount of _____ to cover the above fees.
 A duplicate copy of this sheet is enclosed.

☒ The Commissioner is hereby authorized to charge any fees which may be required, or credit any overpayment to Deposit Account No. **14-1138** A duplicate copy of this sheet is enclosed.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.

SEND ALL CORRESPONDENCE TO:

NOTO, Joseph M.; GOLDMAN, Michael L. MERKEL, Edwin V.; CATON, Georgia Nixon Peabody LLP Clinton Square, P. O. Box 31501 Rochester, New York 14603 United States of America	<div style="text-align: center;">  SIGNATURE Joseph M. Noto NAME 32,163 REGISTRATION NUMBER 9-26-00 DATE </div>
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430 Rec'd PCT/PTO 26 SEP 2000

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant: WHITWORTH, Ian James)
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 U. S. Serial No: To be assigned)
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 Filed: Herewith)
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 PCT International)
 Application No: PCT/GB99/00975)
)
 Filed: 29 March 1999)
)
 Claiming Priority from)
 U.K. Application No: GB 9806778.8)
)
 Priority Date: 31 March 1998)
)
 For : APPARATUS FOR THE PRODUCTION OF)
 POCKETED COIL SPRINGS)
)
)

PRELIMINARY AMENDMENT

Commissioner of Patents
 and Trademarks
 Washington, D.C. 20231
BOX: PCT

Dear Sir:

Please amend the above-identified patent application as follows:

In the Claims:

Please amend claims 5-7, 9-10, 12, 14-15, 18, 20, 23-24, 27, 32, 36, and 39 as follows:

Claim 5, line 1, replace "any preceding claim" with -- Claim 1--.

Claim 6, line 1, replace "any preceding claim" with -- Claim 1--.

Claim 7, line 1, replace "any preceding claim" with -- Claim 1--.

Claim 9, line 1, replace "any preceding claim" with -- Claim 1--.

Claim 10, line 1, replace "any preceding claim" with -- Claim 1--.

Claim 12, line 1, delete "or Claim 11".

Claim 14, line 1, delete "or Claim 13".

Claim 15, line 1, replace "any one of Claims 10 to 13" with -- Claim 10--.

Claim 18, line 1, replace "any preceding claim" with -- Claim 1--.

Claim 20, line 1, replace "any preceding claim" with -- Claim 1--.

Claim 23, line 1, delete "or Claim 22".

Claim 24, line 1, replace "any one of Claims 21 to 23" with -- Claim 21--.

Claim 27, line 1, delete "or Claim 26".

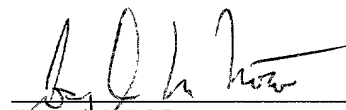
Claim 32, line 2, delete "or Claim 31".

Claim 36, line 1, replace "any one of Claims 33 to 35" with -- Claim 33--.

Claim 39, line 1, delete "or claim 38".

Respectfully submitted,

Date: 9-26-00



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Title: Apparatus for the production of pocketed coil springs

This invention relates to apparatus and methods for the production of pocketed coil springs, and to pocketed spring assemblies.

Pocketed coil springs, ie strings of springs enclosed within fabric pockets which are joined at their side seams, are widely used in the manufacture of mattresses, cushions and the like.

Apparatus for the production of pocketed coil springs may generally be regarded as comprising two sections: a coiling unit in which the coil is formed and an encapsulation section in which the coil is inserted between two layers of material which are then joined together to form a pocket enclosing the spring.

10 The coiling of the wire is commonly achieved by the interaction of three components: feed rollers which pull the wire through the coiler, a so-called "finger" which governs the diameter of the spring as it forms and a so-called "spreader" which controls its pitch. The relative movements of these components define the pattern of the spring that is formed.

Conventionally, synchronisation is achieved by a complex arrangement of gears and cams, making resetting between one product and another a lengthy operation needing high levels of training and experience. Consequently, economic batch quantities are high and response to special customer requirements is slow. Development of new spring designs is difficult, often relying on the creation of new cam profiles on a trial and error basis. In addition, the maximum length of spring which can be produced is often severely limited.

20 The encapsulation section relies on the insertion of the fully compressed springs between the sheets of material, most commonly a folded sheet of non-woven fabric, which are then sewn or welded together to produce the individual pocketed springs. Synchronisation of this section is also dependent on mechanical devices such as cams, linkages and a clutch all of which require resetting between products, with resulting loss of productivity and high

maintenance costs.

There have now been devised improvements to apparatus and methods for the production of pocketed coil springs which overcome or substantially mitigate the above-mentioned disadvantages.

- 5 According to a first aspect of the invention, apparatus for the production of pocketed coil springs comprises a coiling section in which a coil is formed from wire fed to the coiling section, said coiling section comprising coiling elements whose position and/or orientation determines the form of said coil, and an encapsulation section in which the coil is inserted
10 between juxtaposed sheets of material which are joined together to form a pocket enclosing the coil,

wherein said apparatus further comprises programmable control means operably linked to said coiling elements thereby to control the position and/or orientation thereof.

- The apparatus according to the invention is advantageous primarily in that the programmable control means may synchronise all operations of the apparatus, thereby eliminating change
15 gears, cams, clutch etc. The time to change between products is reduced to seconds rather than hours, with consequential benefits to productivity and responsiveness, better quality, smaller batch quantities and reduced work in progress stocks. Development of new products and extensions of the product range can be achieved far more easily without any significant loss of time or materials.

- 20 According to another aspect of the invention, there is provided a method of producing pocketed coil springs, which method comprises the steps of

- a) setting the positions and/or orientations of coiling elements in the coiling section of apparatus in accordance with the first aspect of the invention,
b) feeding wire through the coiling section so as to form a coil,
25 c) separating said coil from said wire,
d) compressing said coil,

- e) inserting said coil between juxtaposed sheets of material, and
- f) joining said sheets of material together so as to encapsulate said coil.

The programmable control means preferably comprises a programmable logic controller by which computer-numerical-control (CNC) of the coiling section is achieved. Preferably, the logic controller actuates drive means, most preferably servo motors, by which the positions and/or orientations of the coiling elements can be altered.

Most preferably, control of the coiling unit is exerted by three servo-motors: one for the wire feed rolls, one for a coiling element ("finger") which controls the diameter of the spring, and one for a coiling element ("spreader") which controls the pitch of the spring.

- 10 Most preferably, the control means stores a number of data arrays or tables which determine the position of the finger and spreader (slave) axes in relation to the position of the feed roller (master) axis, for each spring profile. Suitable tables may be prepared for each spring type to be manufactured, and the appropriate table selected prior to commencement of manufacture of any particular spring type.
- 15 Each table may consist of many data points, eg several thousand data points, resulting in complete control of the spring being formed. In order to facilitate the creation and modification of the tables, they can be created using a computer spreadsheet. This also enables viewing of a graphical representation of the movements of the axes relative to each other prior to the table being downloaded to the logic controller. The use of spreadsheets
- 20 allows total flexibility in the desired spring profile, eg for development purposes. However, for established spring designs, it may simply be adequate to enter the desired pitch and diameter(s).

Any additional spring parameters, eg the number of convolutions or diameter modifications, may be entered directly via a control panel. This enhances changeovers and allows simple correction for variation in wire properties etc.

After each spring has been formed, the feed roll axis servo motor preferably stops completely to allow the wire to be cut, eg by a pneumatic cutter. This is in contrast to a traditional coiling machine where, owing to the inertia in the system, the wire movement is paused by moving the rolls apart from each other whilst they continue to rotate. This requires
5 considerably more moving parts which are prone to mechanical failure.

The apparatus of the present invention makes it possible to achieve higher production speeds than with a conventional coiler. When producing longer springs, this higher speed can lead to instability in the spring as it is being formed which can result in machine stoppages. This problem can be reduced or eliminated by damping excessive oscillations of the springs. This
10 can be achieved by providing magnetic means at the exit of the coiling unit. The magnet means engages the spring as it leaves the coiling unit, thereby damping oscillations of the spring and enabling springs of greater length to be produced. This in turn enables pocketed spring assemblies of greater depth to be manufactured with increased comfort for users of mattresses or the like incorporating such assemblies. The provision of such magnetic
15 damping means at the exit of the coiler is believed to be novel and represents a further aspect of the invention.

Preferably, the magnet means comprises one or more electromagnets, and preferably the spring is mechanically drawn from the magnet means as it is conveyed to the encapsulation section.

20 The invention enables the production of longer springs, and hence deeper pocketed spring assemblies than has hitherto been possible. Thus, according to another aspect of the invention, there is provided a pocketed spring assembly having a depth of 20cm or more. The depth of the pockets could be as much as 30cm or even more in some applications, typical depths being approximately 21cm, 24cm and 25cm. Because the springs in such
25 spring assemblies are constrained within the pockets in a somewhat compressed state, the length of the spring itself, in a non-compressed condition, will be somewhat greater than the pocket depth. A spring for use in a 21cm deep pocket might, for example, have a non-

compressed depth of about 25cm.

Preferably, the programmable control means is also operably linked to the encapsulation section, in particular to control movement of material through that unit. Most preferably, a further servo motor controls movement of the material, the increment of that motor
5 corresponding to the desired pocket width, which can thereby be automatically adjusted to suit the spring diameter.

The means by which the springs are transferred to the encapsulation unit and inserted between the sheets of material may be generally conventional. Preferably, the springs are loaded onto successive radial arms of a rotating wheel. The springs are preferably
10 mechanically compressed as they are conveyed to the encapsulation section so that they are substantially fully compressed when inserted between the sheets of material. Most preferably, the compressed spring is transferred to a reciprocating cassette within which it is transported to the encapsulation section.

The material in which the pockets are formed may have any suitable form. For example, the
15 material may be either a non-woven or woven fabric. The pockets in the fabric may be formed by any suitable means. Such means include stitching, but it is preferred to form the pockets by thermal welding of the two sheets of material. For this reason, it is preferred that the material be of a fabric which is thermoplastic, and in particular that it be of a non-woven thermoplastic material. One suitable material is a non-woven polypropylene. Most
20 preferably, the two sheets of material are formed by folding of a single sheet having a width approximately double the desired depth of the pockets. In such a case, each pocket is defined between two transverse welds and one longitudinal weld which closes the open end of the pocket through which the spring has been inserted.

Welding of the two sheets of material can be carried out in any suitable fashion. However,
25 it is preferred to use ultrasonic welding. The welds are preferably interrupted, rather than continuous, and are therefore most preferably formed using ultrasonic welding horns with

suitably formed, eg castellated, lower edges.

It is particularly preferred that each transverse weld be formed by a plurality, most preferably a pair, of castellated welding horns, and in particular by a plurality of welding horns arranged side-by-side, ie with their lower edges arranged colinearly. This arrangement is believed to be novel and represents a further aspect of the present invention, as does a method of producing pocketed coil springs which utilises such an arrangement. It enables production of significantly deeper pocket units, whilst maintaining commonality of spares etc. Moreover, should there be any wear of the welding horn caused by misaligned springs this will be restricted to the adjacent ends of the two horns, which can in time be turned through 180°, avoiding the need to regrind them.

The transverse welds need to be formed at a separation from the centre of the springs, as they are introduced into the encapsulation section, which is equal to an integral number of pocket widths plus one-half of the pocket width. Since the pocket width may be changed to accommodate a different type of spring it is preferred that the position of the welds be adjustable to satisfy this requirement. Thus, means are preferably provided for alteration of the position of the position of the transverse welding means relative to the point of insertion of the springs into the encapsulation unit. In general, if the welds are to be formed at a distance of $(n + 0.5)$ times the pocket width (where n is an integer) then the position of the welding means needs to be adjustable in a range $(n + 0.5)$ times the difference between the smallest and greatest pocket widths which are to be formed. For example, if the pocket width varies between 8cm and 10cm, and the welds are formed 2.5 pocket widths from the point of encapsulation of the springs, then the welding means need to be displaceable over a range of at least 5cm.

The welding means may be slidably mounted on suitable guide rails and may be driven by a suitable rack and pinion mechanism or the like. The required position of the welding means may be calculated automatically by the control means, and the position of the welding means may be altered automatically, or the required position may be displayed and the

welding means positioned manually.

The fixed anvil onto which the or each welding horn presses the material is preferably provided with a surface coating which acts as a cushion for the welding horn, leading to a more consistent weld and enabling the use of lighter fabrics than is otherwise the case.

- 5 Again, such an arrangement is believed to be novel and represents a further aspect of the invention. The surface coating is preferably a tape applied to the surface of the anvil. The tape is most preferably a polytetrafluoroethylene (PTFE) tape.

The pockets are preferably completed by longitudinal welds formed by a welding horn disposed parallel to the direction of travel of the fabric.

- 10 Most preferably, the material is drawn through the encapsulation section by means of rollers. It is preferred that the material pass between a pair of horizontally disposed rollers, one of which is driven by a servo motor controlled by the control means. Such rollers are preferably located downstream of the welding means. Most preferably the rollers have rubberised surfaces to improve engagement of the rollers with the fabric.

- 15 Other components of the apparatus, downstream of the welding horns, may be generally conventional. Such components may include a worm gear which rotates transverse to the direction of travel of the completed pockets and which serves to orient the springs as they expand within the pockets.

- 20 The invention will now be described in greater detail, by way of example only, with reference to the accompanying drawings, in which

Figure 1 is a diagrammatic view of a coiling unit forming part of an apparatus according to the invention;

Figure 2 is a schematic view of the coiling unit and spring transfer assembly forming part of

the apparatus;

Figure 3 is a detailed scrap view on the line III in Figure 2;

Figure 4 is a schematic view of an encapsulation section forming part of the apparatus;

Figure 5 is a front schematic view of a transverse ultrasonic welding arrangement forming
5 part of the encapsulation section of Figure 4; and

Figure 6 is a partial perspective view of a pocketed spring assembly.

Referring first to Figure 1, a coiling unit of an apparatus according to the invention is shown schematically and comprises three components which determine the form of the coil produced from wire 1 fed into the unit by conventional means. Those three components are
10 a pair of feed rollers 2,3, a coiling finger 4 and a so-called spreader 5. The feed rollers 2,3 determine the axis along which the wire is fed to the finger 4 and spreader 5. This is the master axis in relation to which the orientational axes (slave axes) of the finger 4 and spreader 5 are adjusted. The orientation of the finger 4 and spreader 5 are governed by servo-motors 6,7 which are controlled by a programmable logic controller (PLC) 8. The PLC
15 8 is in turn linked to a computer control panel 9. Connection of the control panel 9 to the PLC 8 may be necessary only some of the time, eg for downloading of data to the PLC 8 or monitoring operation of the PLC 8. At other times, eg during normal operation, such connection may be unnecessary.

Figure 2 shows a transfer mechanism by which coils produced in the coiling unit (generally
20 designated in Figure 2 by the numeral 10) are fed to an encapsulation section described below. The transfer mechanism comprises a counter-clockwise rotating wheel 11 with eight radially extending arms 12. Rotation of the wheel 11 is synchronised with the operation of the coiling unit 10 such that springs 20 produced in the coiling unit 10 are fed automatically onto the arms 12 as the arms 12 pass the exit from the coiling unit 10.

As the wheel 11 rotates further, the arms 12 carrying the springs 20 pass along longitudinal slots in a pair of compression plates 13,14, the space between which is progressively reduced, causing the springs 20 to be compressed. The terminal portions of the compression plates 13,14 are disposed parallel and horizontally so as to constitute a delivery chute from which the compressed springs 20 are delivered to a reciprocating cassette 15 which moves as indicated by the double-headed arrow. The cassette 15 transfers the springs 20 to the encapsulation unit and in particular to the space between the two leaves of a folded sheet of non-woven fabric 25 (shown in broken lines). When the cassette 15 is located between the leaves of fabric 25, a pneumatically driven rod 16 is raised and engages the spring 20 through the lower leaf and a slot in the base of the cassette 15. This rod 16 retains the spring 20 in position when the cassette 15 is withdrawn from the fabric 25.

Excessive oscillations of the springs 20 as they exit the coiling unit 10 and are loaded onto the arms 12 are prevented by a pair of electromagnets 27 (see Figure 3) mounted on the topmost parts of the upper compression plate 13, either side of the longitudinal slot 28 running down the centre of that compression plate 13. The electromagnets 27 hold each spring 20 as it exits the coiling unit 10 until the corresponding arm 12 of the wheel 11 transports the spring 20 away.

Figure 4 shows the encapsulation unit 40, the operating axis of which is disposed perpendicular to that of the coiling unit 10. The sheet 25 of fabric is folded by conventional means (not shown) and fed through the encapsulation unit 40 from right to left, as viewed in Figure 4, and in incremental steps. The sheet 25 passes first between a pair of guide rollers 41. A fixed separating guide (not shown) then parts the two leaves of the sheet 25 sufficiently for a spring 20 to be inserted between them as described above. The sheet 25 is then transported forward by one increment, so that the next spring 20 can be delivered into the space between the leaves of the sheet 25 from the next arm 12 of the wheel 11.

The spring 20 is maintained in a compressed condition by a cover plate 42 which, together with the bed of the encapsulation unit 40, defines a channel through which the encapsulated

springs 20 are transported.

Following incremental travel of the sheet 25, the two leaves of the sheet 25 are joined by transverse welds formed by a first reciprocating welding horn arrangement 43 which is described more fully below. A further welding horn 44 forms a longitudinal weld which
5 completes the encapsulation of the springs 20.

A second cover plate 45 extends from the region of the first welding horn arrangement 43, past the further welding horn 44 and also past a drive roller arrangement 46,47 which acts on the folded fabric sheet 25 so as incrementally to draw the sheet 25 through the encapsulation unit 40. The drive roller arrangement 46,47 comprises a driven roller 46 which
10 acts on the underside of the sheet 25 and a second roller 47 which is pneumatically pressurised into engagement with the upper surface of the sheet 25. Both rollers 46,47 have rubberised surfaces, the rubberised surface of the upper roller 47 being partly cut away to accommodate the second cover plate 45.

As the encapsulated springs 20 emerge from the channel between the second cover plate 45 and the bed of the encapsulation unit 40 they expand and are rotated into the desired orientation, in which the spring axis is transverse to the pockets, by a rotating worm 48. The finished product has the form of a string of springs enclosed within pockets formed in the non-woven fabric, the pockets being connected at the weld lines which define the sides of the pockets.
15

The reciprocating motion of the first welding arrangement 43 and of the further welding horn 44 is synchronised with the incremental actuation of the drive roller arrangement 46,47 again under the control of the PLC 8.
20

As shown in Figure 5, the first welding arrangement 43 comprises a pair of ultrasonic welding horns 51,52 arranged side by side. The horns 51,52 reciprocate on a vertical axis, and at the lowest point of their travel press the fabric sheet 25 onto a corresponding pair of
25

anvils 53,54. The folded sheet 25 of fabric, with a spring 20 inserted between the two leaves of the sheet 25, travels between the anvils 53,54 and the horns 51,52 when the horns 51,52 are raised.

By using two welding horns 51,52 it is possible to achieve a greater length of weld than would be possible using only one horn, and hence deeper pockets containing longer springs may be formed.

The lower edge of each horn 51,52 is castellated. After each incremental travel of the sheet 25, the horns 51,52 are lowered and compress the two leaves of the sheet 25 together and join the two leaves in a weld. Because of the castellated form of the lower edge of each horn 51,52, the weld has the form of an interrupted, rather than continuous, line. This is found to confer greater tensile strength on the finished string of pocketed springs.

The upper surface of each of the anvils 53,54 carries a strip of polytetrafluoroethylene tape 55,56. This cushions the contact of the welding horns 51,52 with the fabric 25 and leads to more consistent weld formation and enables the use of lighter weight fabrics than would otherwise be the case.

Referring finally to Figure 6, a pocketed spring assembly 60 comprises strings of pocketed springs such as energy from the encapsulation unit 40 arranged side-by-side and fastened together to form a generally rectangular assembly. The strings of springs may be fastened together by any suitable means, eg gluing, stitching or mechanical fasteners. The depth d of the assembly 60 may be substantially greater than that of conventional pocketed spring assemblies.

Claims

1. Apparatus for the production of pocketed coil springs, comprising
a coiling section in which a coil is formed from wire fed to the coiling section, said
coiling section comprising coiling elements whose position and/or orientation determines the
5 form of said coil, and
an encapsulation section in which the coil is inserted between juxtaposed sheets of
material and in which the sheets of material are joined together to form a pocket enclosing
the coil,
wherein said apparatus further comprises programmable control means operably
10 linked to said coiling elements thereby to control the position and/or orientation thereof.
2. Apparatus as claimed in Claim 1, wherein the programmable control means comprises
a programmable logic controller by which computer-numerical-control of the coiling section
is achieved.
3. Apparatus as claimed in Claim 2, wherein the logic controller actuates drive means
15 by which the positions and/or orientations of the coiling elements can be altered.
4. Apparatus as claimed in Claim 3, wherein said drive means comprises three motors,
one for the wire feed rolls, one for a coiling element which controls the diameter of the
spring, and one for a coiling element which controls the pitch of the spring.
5. Apparatus as claimed in any preceding claim, wherein the control means stores data
20 arrays or tables which determine the position of the axes of the coiling elements in relation
to the position of the feed roller axis.
6. Apparatus as claimed in any preceding claim, wherein one or more electromagnets
are mounted at the exit of the coiling unit, said one or more electromagnets engaging each
spring as it leaves the coiling unit, said spring being mechanically drawn away from said one

or more electromagnets as said spring is conveyed to the encapsulation section.

7. Apparatus as claimed in any preceding claim, wherein the programmable control means is also operably linked to the encapsulation section, to control movement of material through the encapsulation section.

5 8. Apparatus as claimed in Claim 7, wherein a servo motor operably linked to the programmable control means controls movement of the material through the encapsulation section, such that said material is advanced in increments corresponding to the desired pocket width.

9. Apparatus as claimed in any preceding claim, wherein the means by which the springs
10 are transferred to the encapsulation unit and inserted between the sheets of material comprises a rotating wheel with radially extending arms, successively formed springs being engaged by successive arms of said wheel;

means for compressing the springs as they are conveyed to the encapsulation section on the arms of said rotating wheel; and

15 a reciprocating cassette into which the compressed springs are delivered by said wheel and within which the compressed springs are transported to the encapsulation section.

10. Apparatus as claimed in any preceding claim, which further comprises ultrasonic welding means by which the sheets of material are joined together to form pockets.

11. Apparatus as claimed in Claim 10, wherein said ultrasonic welding means comprises
20 longitudinal welding means arranged parallel to the longitudinal axis of the sheets of material and transverse welding means arranged transverse to said axis.

12. Apparatus as claimed in Claim 10 or Claim 11, wherein said ultrasonic welding means comprises ultrasonic welding horns with castellated lower edges.

13. Apparatus as claimed in Claim 11, wherein said transverse welding means comprises a pair of welding horns arranged colinearly.
14. Apparatus as claimed in Claim 12 or Claim 13, wherein means are provided for alteration of the position of the transverse welding means on said longitudinal axis of said
5 sheets of material.
15. Apparatus as claimed in any one of Claims 10 to 13, wherein the ultrasonic welding means comprise ultrasonic welding horns, at least one of which acts against a fixed anvil provided with a surface coating which acts as a cushion for said welding horn.
16. Apparatus as claimed in Claim 15, wherein said surface coating comprises a tape
10 applied to the surface of the anvil.
17. Apparatus as claimed in Claim 16, wherein said tape is a polytetrafluoroethylene tape.
18. Apparatus as claimed in any preceding claim, wherein said sheets of material are drawn through the encapsulation section by means of a pair of horizontally disposed rollers,
15 one of which is driven by a servo motor controlled by the programmable control means.
19. Apparatus as claimed in Claim 18, wherein said rollers have rubberised surfaces.
20. Apparatus as claimed in any preceding claim, wherein said encapsulation section comprises transport means for drawing said sheets of material incrementally through the encapsulation section and welding means for welding the sheets of material together,
20 wherein the transport means and the welding means are controlled by the programmable control means.

21. A method of producing pocketed coil springs, which method comprises the steps of
a) setting the positions and/or orientations of coiling elements in the coiling section
of apparatus as claimed in any preceding claim,
b) feeding wire through the coiling section so as to form a coil,
5 c) separating said coil from said wire,
d) compressing said coil,
e) inserting said coil between juxtaposed sheets of material, and
f) joining said sheets of material together so as to encapsulate said coil.
22. A method as claimed in Claim 21, wherein the positions and/or orientations of the
10 coiling elements are set in accordance with a data array stored in the programmable control means.
23. A method as claimed in Claim 21 or Claim 22, wherein the positions and/or orientations of the coiling elements are set by servo motors operating under control of the programmable control means.
- 15 24. A pocketed coil spring assembly produced in accordance with the method of any one of Claims 21 to 23.
25. Apparatus for the production of pocketed coil springs, comprising
a coiling section in which a coil is formed from wire fed to the coiling section, said coiling section comprising coiling elements whose position and/or orientation determines the
20 form of said coil, and
an encapsulation section in which the coil is inserted between juxtaposed sheets of material and in which the sheets of material are joined together to form a pocket enclosing the coil,
wherein said encapsulation section comprises at least one ultrasonic welding horn
25 arranged parallel to the longitudinal axis of the sheets of material, and a plurality of transverse welding horns arranged colinearly and transverse to the longitudinal axis of the

sheets of material.

26. Apparatus as claimed in Claim 25, wherein means are provided for alteration of the position of the position of the transverse welding horns on said longitudinal axis of said sheets of material.

5 27. Apparatus as claimed in Claim 25 or Claim 26, wherein at least one of said ultrasonic welding horns acts against a fixed anvil provided with a surface coating which acts as a cushion for said welding horn.

28. Apparatus as claimed in Claim 27, wherein said surface coating comprises a tape applied to the surface of the anvil.

10 29. Apparatus as claimed in Claim 28, wherein said tape is a polytetrafluoroethylene tape.

30. A method of producing pocketed coil springs, which method comprises inserting a compressed coil spring between juxtaposed sheets of material, and joining said sheets together by means of ultrasonic welds arranged parallel to and transverse to the longitudinal axis of said sheets so as to encapsulate said spring therebetween, wherein the ultrasonic welds transverse to the longitudinal axis of said sheets are formed by a plurality of ultrasonic welding horns with their lower edges arranged colinearly.

15

31. A method as claimed in Claim 30, wherein the lower edges of the welding horns are castellated.

20 32. A pocketed coil spring assembly produced in accordance with the method of Claim 30 or Claim 31.

33. Apparatus for the production of pocketed coil springs, comprising

a coiling section in which a coil is formed from wire fed to the coiling section, said coiling section comprising coiling elements whose position and/or orientation determines the form of said coil, and

an encapsulation section in which the coil is inserted between juxtaposed sheets of material and in which the sheets of material are joined together to form a pocket enclosing the coil,

wherein said encapsulation section comprises at least one ultrasonic welding horn which acts against a fixed anvil provided with a surface coating which acts as a cushion for said welding horn.

34. Apparatus as claimed in Claim 33, wherein said surface coating comprises a tape applied to the surface of the anvil.

35. Apparatus as claimed in Claim 34, wherein said tape is a polytetrafluoroethylene tape.

36. Apparatus as claimed in any one of Claims 33 to 35, comprising at least one ultrasonic welding horn arranged parallel to the longitudinal axis of the sheets of material, and a pair of welding horns arranged colinearly and transverse to the longitudinal axis of the sheets of material.

37. Apparatus for the production of pocketed coil springs, comprising
a coiling section in which a coil is formed from wire fed to the coiling section, said coiling section comprising coiling elements whose position and/or orientation determines the form of said coil, and

an encapsulation section in which the coil is inserted between juxtaposed sheets of material and in which the sheets of material are joined together to form a pocket enclosing the coil,

wherein there are provided magnetic means at an exit of the coiling section, which magnetic means engage the coil so as to damp oscillation thereof.

38. Apparatus as claimed in claim 37, wherein said magnetic means comprises one or more electromagnets.

39. Apparatus as claimed in claim 37 or claim 38, wherein the coil is mechanically drawn from the magnetic means as it is conveyed from the coiling section to the encapsulation
5 section.

40. A pocketed spring assembly having a depth of 20cm or more.

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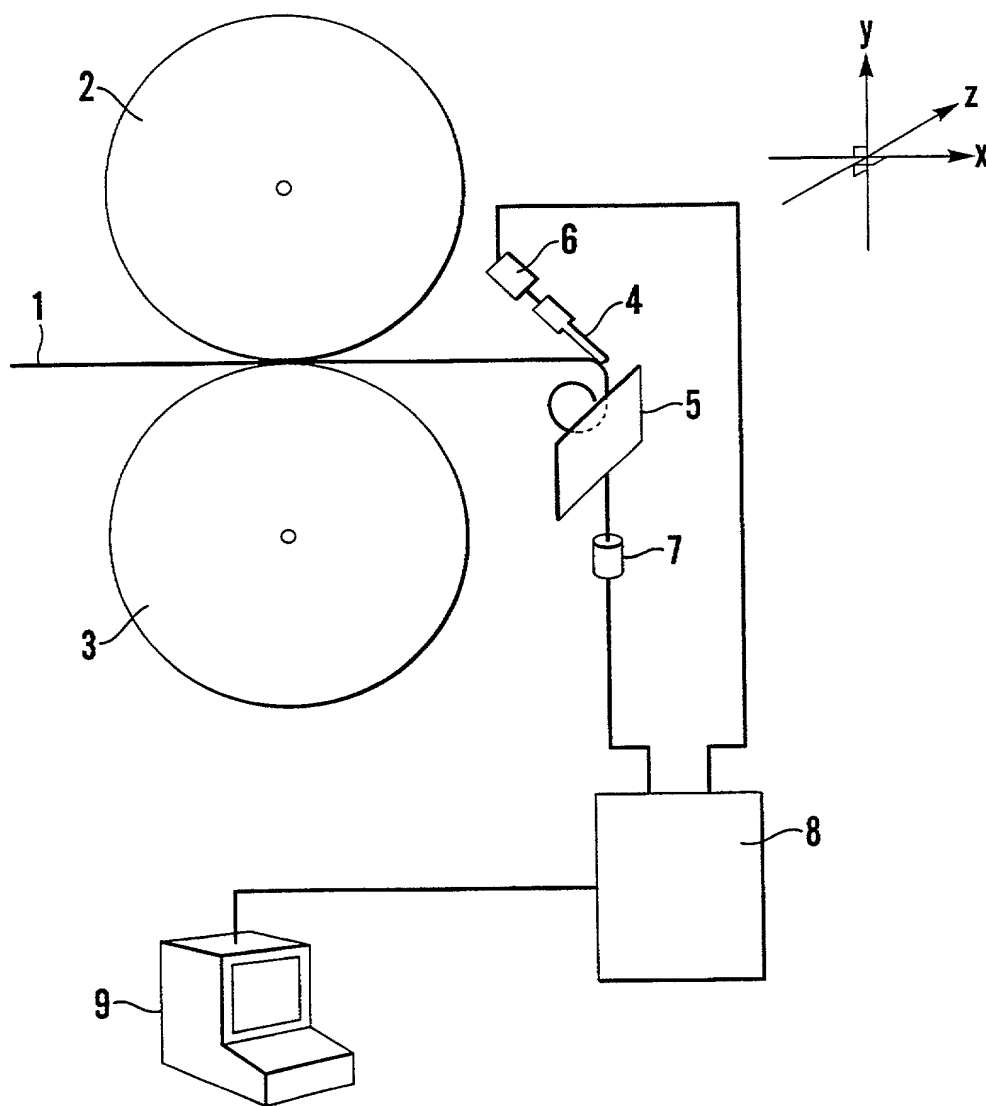


Fig. 1

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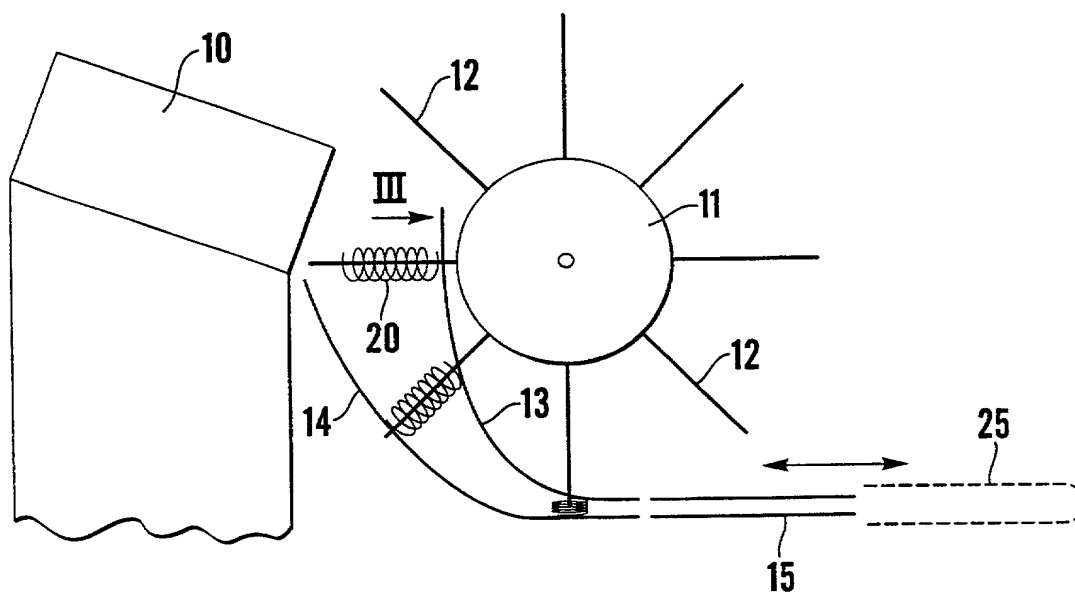


Fig. 2

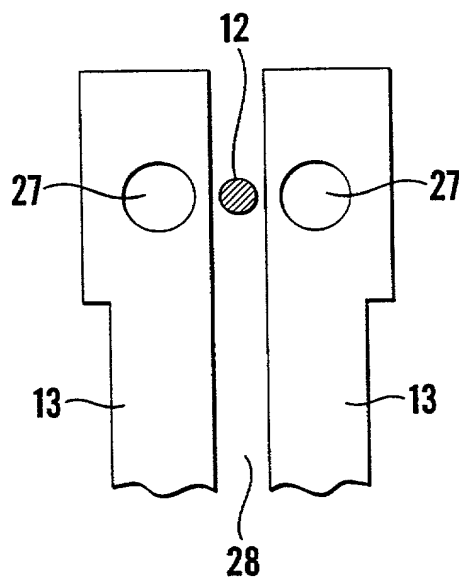


Fig. 3

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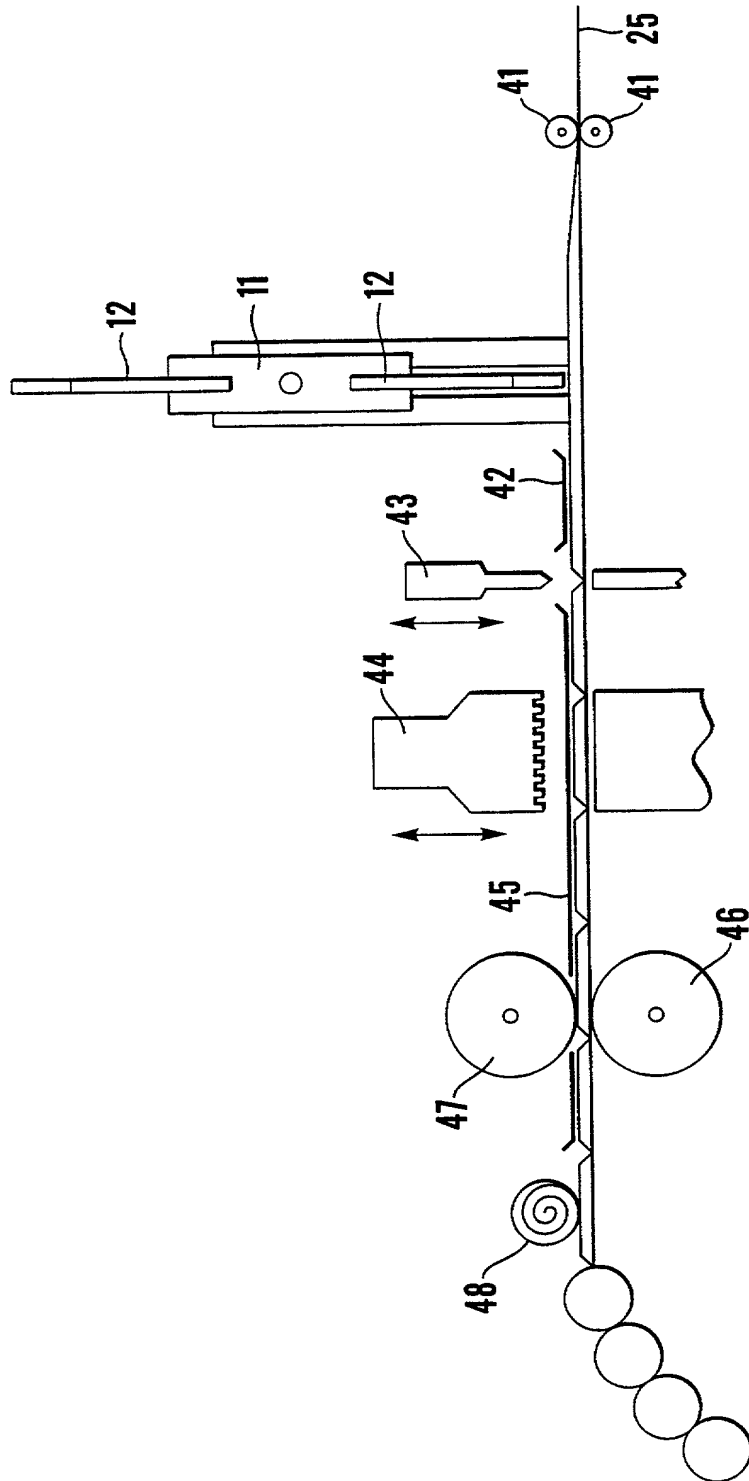


Fig. 4

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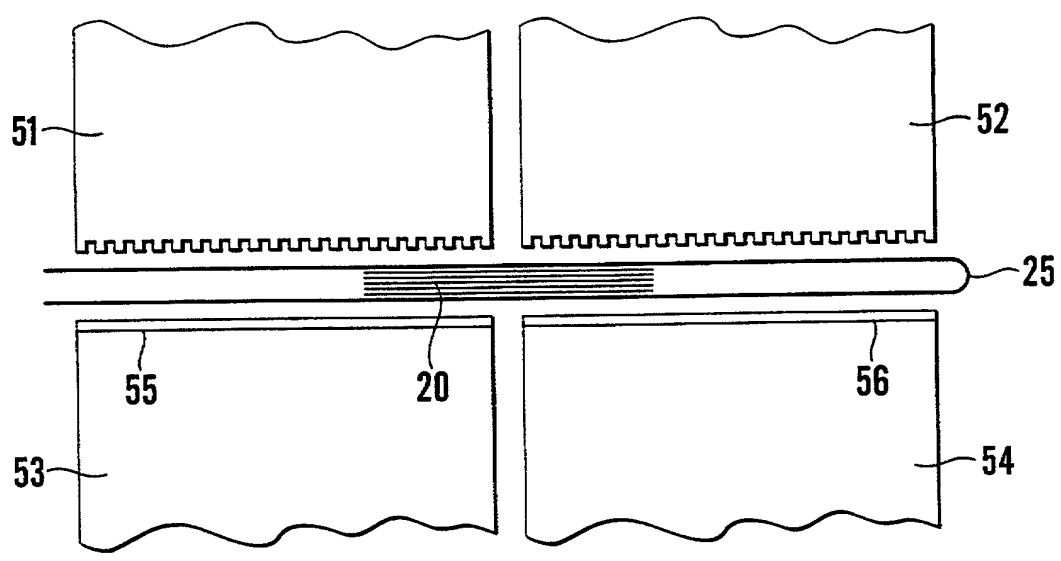


Fig. 5

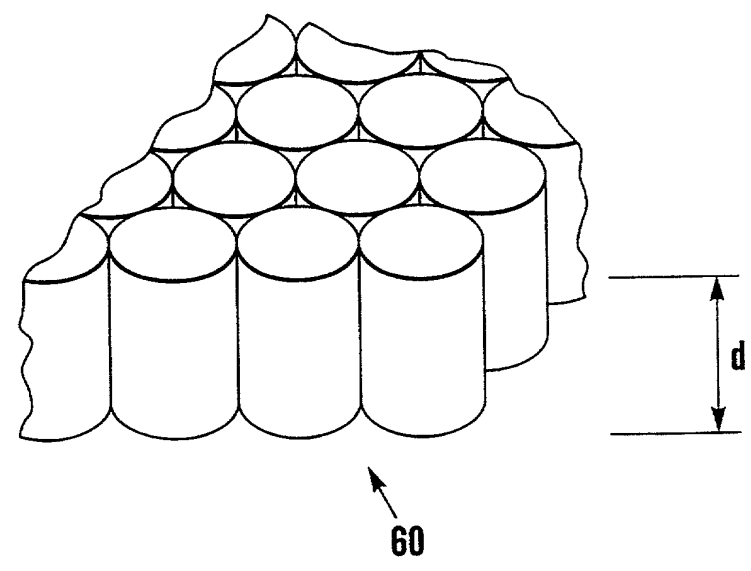


Fig. 6

COMBINED DECLARATION FOR PATENT
APPLICATION AND POWER OF ATTORNEY
(Includes Reference to PCT International Applications)

ATTORNEY'S DOCKET NUMBER
2308/100

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

APPARATUS FOR THE PRODUCTION OF POCKETED COIL SPRINGS

the specification of which (check only one item below):

☐ is attached hereto.

☐ was filed as U.S. Patent Application Serial No. _____ on _____ and was amended on _____ (if applicable).

☒ was filed as PCT International Application Number **PCT/GB99/00975** on **29 March 1999** and assigned U.S. Serial Number. **09/647,087**.

I hereby state that I have reviewed and understand the contents of the above-identified specifications, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the patentability of this application in accordance with Title 37, Code of Federal Regulations, § 1.56(a).

I hereby claim foreign priority benefits under Title 35, United States Code, § 119 of any foreign application(s) for patent or inventor's certificate or of any PCT international application(s) designating at least one country other than the United States listed below and have also identified below any foreign application(s) for patent or inventor's certificate or any PCT international application(s) designating at least one country other than the United States of America filed by me on the same subject matter having a filing date before that of the application(s) of which priority is claimed:

PRIOR APPLICATION(S) AND ANY PRIORITY CLAIMS UNDER 35 U.S.C. 119:

COUNTRY (IF PCT, indicate "PCT")	APPLICATION NUMBER	DATE OF FILING (day, month, year)	PRIORITY CLAIMED UNDER 35 USC 119
PCT	PCT/GB99/00975	29 March 1999	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO
Great Britain	GB 9806778.8	31 March 1998	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO
			<input type="checkbox"/> YES <input type="checkbox"/> NO
			<input type="checkbox"/> YES <input type="checkbox"/> NO
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			<input type="checkbox"/> YES <input type="checkbox"/> NO
			<input type="checkbox"/> YES <input type="checkbox"/> NO
			<input type="checkbox"/> YES <input type="checkbox"/> NO

**COMBINED DECLARATION FOR PATENT
APPLICATION AND POWER OF ATTORNEY (Continued)**
(Includes Reference to PCT International Applications)

ATTORNEY'S DOCKET NUMBER
2308/100

I hereby claim the benefit under Title 35, United States Code, § 120 of any United States application(s) or PCT international application(s) designating the United States of America that is/are listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in that/those prior application(s) in the manner provided by the first paragraph of Title 35, United States Code, § 112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, § 1.56(a) which occurred between the filing date of the prior application(s) and the national or PCT International filing date of this application:

PRIOR U.S. APPLICATIONS OR PCT INTERNATIONAL APPLICATIONS DESIGNATING THE U.S. FOR BENEFIT UNDER 35 U.S.C. 120:

U.S. APPLICATIONS		STATUS (Check One)		
U.S. APPLICATION NUMBER	U.S. FILING DATE	PATENTED	PENDING	ABANDONED
PCT APPLICATIONS DESIGNATING THE U.S.				
PCT APPLICATION NO.	PCT FILING DATE	U.S. SERIAL NUMBERS ASSIGNED (if any)		
PCT/GB99/00975	29 March 1999		X	

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. **Georgia Caton, Registration No. 44,597; Alice Y. Choi, Registration No. 45,758; Michael L. Goldman, Registration No. 30,727; Gunnar G. Leinberg, Registration No. 35,584; Edwin V. Merkel, Registration No. 40,087; Joseph M. Noto, Registration No. 32,162; Ann R. Pokalsky, Registration No. 34,697; Grant E. Pollack, Registration No. 34,097**

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202	FULL NAME OF INVENTOR	FAMILY NAME	FIRST GIVEN NAME	SECOND GIVEN NAME
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	POST OFFICE ADDRESS	P.O. ADDRESS	CITY	STATE & ZIP CODE/COUNTRY
203	FULL NAME OF INVENTOR	FAMILY NAME	FIRST GIVEN NAME	SECOND GIVEN NAME
	RESIDENCE & CITIZENSHIP	CITY	STATE/FOREIGN COUNTRY	COUNTRY OF CITIZENSHIP
	POST OFFICE ADDRESS	P.O. ADDRESS	CITY	STATE & ZIP CODE/COUNTRY

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

SIGNATURE OF INVENTOR 201

SIGNATURE OF INVENTOR 202

SIGNATURE OF INVENTOR 203

DATE

17/11/2000

DATE

DATE